

Work Order ID 78185

78185

January-02-12 10:08:26 AM

Page 1

Item ID: D412-630-031

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Stop

NS2

Start Date: 02/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/08 Tooling:

Date:

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	SP -
----------	--------------	------

IIN D412-630	Rev M	SP -
--------------	-------	------

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

12/01/08

W 12 01 08 (4)
J For M.L.J 12-2-1 (4)

110

110

Small Fab

Small Fab

Memo

0.00

Assemble as per IIN D412-630

Small Fab

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

12/01/08

(4)
UH

Memo

0.00

****ensure tension to retract step is 11 to 18 lbs ****

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D412-630-031

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 02/01/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 31/01/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

Pick Kit

0.00

130

Packaging

Memo

0.00

SP 12-02-01.

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Quality Control

Memo

0.00

Sizloz/10

IN 12-02-08 (J)

150

150

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev:

D

SP 12-02-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 78185

January-02-12 10:08:26 AM

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Page 3

Item ID: D412-630-031

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Stop

NS2

Start Date: 02/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

160

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC

Quality Control

0.00

Memo

0.00

12/2/10 JH

h [2-02-10]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: NC Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 78185

78185

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV. A	05.11.21	NEW ISSUE	EC
IPP REV. B	05.12.19	updated pick list	EC
IPP REV. C	07.11.12	ecn 1019,no chg	EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4		Purchased	No			130	Each	28.0000	1	4		**	

S *AN310-4*
NUT

Location	Loc Qty	Loc Code
ST344	28	
119328	13	
119799	15	

S *AN310-5*
NUT

Location	Loc Qty	Loc Code
ST344	28	
119799	15	

AN3C5A
Bolt
AN3C5A

Location	Loc Qty	Loc Code
ST344	28	
118112	28	

Location	Loc Qty	Loc Code
FP001	7	
115835	7	

Location	Loc Qty	Loc Code
ST350	857	
116419	28	
117343	17	
117764	49	
117872	2	
119127	500	
119749	261	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: NC Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Page 2

January-02-12 10:08:31 AM

Work Order ID: 78185

78185

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

AN44-C12

Purchased

No

130

Each

8.0000

1 4

**

M12039S

AN44-C12

eyebolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST362	8	
117616	8	

AN4C15

Purchased

No

130

Each

21.0000

1 4

**

AN4C15

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST358	21	
118652	11	
119531	10	

AN5C11

Purchased

No

130

Each

18.0000

1 4

**

AN5C11

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST337	18	
114801	18	

AN5C15

Purchased

No

130

Each

12.0000

1 4

**

AN5C15

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST338	12	
117616	12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: NC Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 78185

78185
D412-630-031

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

AN960C516

Purchased No

[130]

Each

16.0000

1

4

**

1
4
Sf

AN960C516

WASHER

D3454-1

Manufactured No

102842

[130]

Each

25.0000

1

4

**

1
4
Sf

D3454-1

Bushing

D3454-3

Manufactured No

58555
74730

[130]

Each

20.0000

2

8

**

1
3
Sf

D3454-3

Bushing

D3454-5

Manufactured No

73348

[130]

Each

22.0000

2

8

**

8
26/854
Q

D3454-5

Bushing

Location

Loc Qty

Loc Code

ST054

20

70527

2

73343

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78185

78185
D412-630-031

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

D3455-1

Manufactured No

130

Each

57.0000

4

16

31

**

B77568

D3455-1

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST054	57	
73302	27	
77043	30	

D3455-3

Manufactured No

130

Each

42.0000

2

B

SP

D3455-3

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST054	42	
72163	14	
76958	28	

D3462-041

D3462-041
Bracket Assembly

MS21043-3

MS21043-3

Nut

Manufactured No

130

Each

0.0000

1

**

8

4

2

B71703 SP.

B78712 SP 12-02-01

12

SP 12-02-01

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	72	
103691	72	
ST300	750	
119901	750	
ST301	647	
118077	2	
118614	441	
118686	30	
119758	174	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 78185

78185

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

MS24665-227

Purchased

No

130

Each

78.0000

2 8

**

SP

MS24665-227

COTTER PIN

Location	Loc Qty	Loc Code
ST309	78	
111041	78	

MS24665-229

Purchased

No

130

Each

293.0000

2

8x
8

SP

MS24665-229

COTTER PIN

Location	Loc Qty	Loc Code
ST309	293	
111041	102	
118234	191	

NAS1149C0363R

Purchased

No

130

Each

3,734.000

7

8x
28

SP

NAS1149C0363R

Washer

Location	Loc Qty	Loc Code
ST297	3734	
114742	3734	

NAS1515H5

Purchased

No

130

Each

109.0000

1

28x
4

SP 12-02-01

NAS1515H5

Washer

Location	Loc Qty	Loc Code
FG	40	
103286	20	
103691	20	

D3463-041

Manufactured

No

110

Each

0.0000

1

4x

SP 12-02-01

D3463-041

Step Weldment Assembly

B78206(4x)

**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78185

78185

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

D3443-043

Manufactured No

110

Each

0.0000

1

4

**

B7602304X SP

D3443-043

Strut Weldment Assembly

D3443-041

Manufactured No

110

Each

3.0000

1

4

**

B736123X SP

D3443-041

Strut Weldment Assembly

D3443-9

Manufactured No

110

Each

28.0000

2

8

**

B776910X SP

D3443-9

Pin

Location

Loc Qty

Loc Code

ST198A

3

72027

3

D3454-7

Manufactured No

110

Each

22.0000

2

8

**

D3454-7

Bushing

Location

Loc Qty

Loc Code

ST054

28

74699

8

76959

20

D3455-1

Manufactured No

110

Each

57.0000

2

8

**

D3455-1

Spacer

Location

Loc Qty

Loc Code

ST054

57

73302

27

77043

30

3X
3X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January-02-12 10:08:31 AM

Work Order ID: 78185

78185

Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

D3465-1

Manufactured No

110

Each

21.0000

1

4

**

SP

D3465-1

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST054	21	
46134	1	
73449	20	

AN4CH3

Purchased No

110

Each

32.0000

2

8

**

4X

SP

AN4CH3

SS Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	32	
117616	1	
118131	1	
118757	10	
118758	20	

AN4C14

Purchased No

110

Each

24.0000

1

4

**

3X

5X

SP

AN4C14

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	24	
117688	24	

AN310-4

Purchased No

110

Each

28.0000

1

4

**

4X

SP 12-02-01

AN310-4

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST344	28	
119328	13	
119799	15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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January-02-12 10:08:31 AM

Work Order ID: 78185

78185
D412-630-031

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

AN310-7

Purchased

No

110

Each

36.0000

1

4

**

SP

AN310-7

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST344	36	
<u>114784</u>	26	
<u>119749</u>	10	

MS24665-227

Purchased

No

110

Each

78.0000

1

4

**

SP

MS24665-227

COTTER PIN

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST309	78	
<u>111041</u>	78	

MS24665-302

Purchased

No

110

Each

81.0000

1

4

**

SP 12-02-01

MS24665-302

Cotter Pin

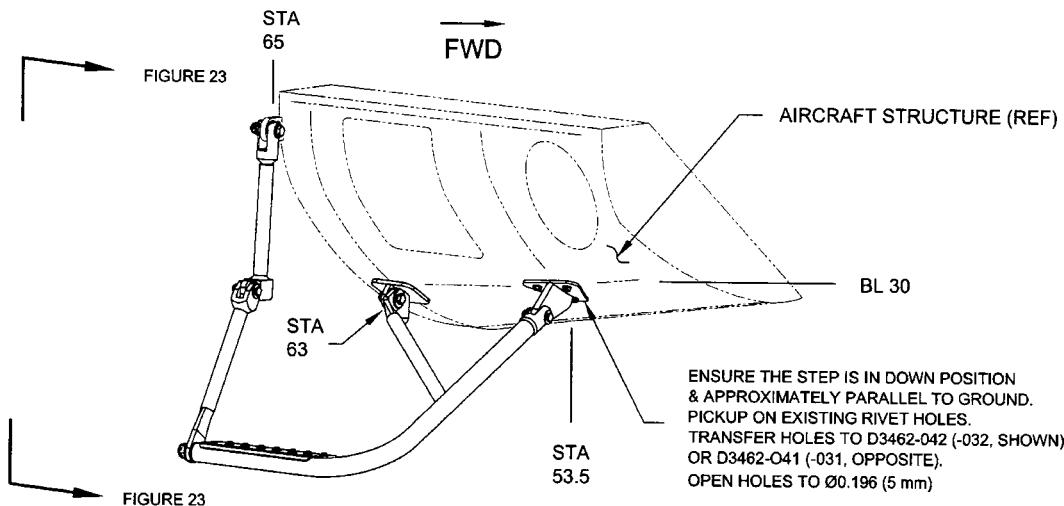
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST309	81	
<u>117460</u>	81	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

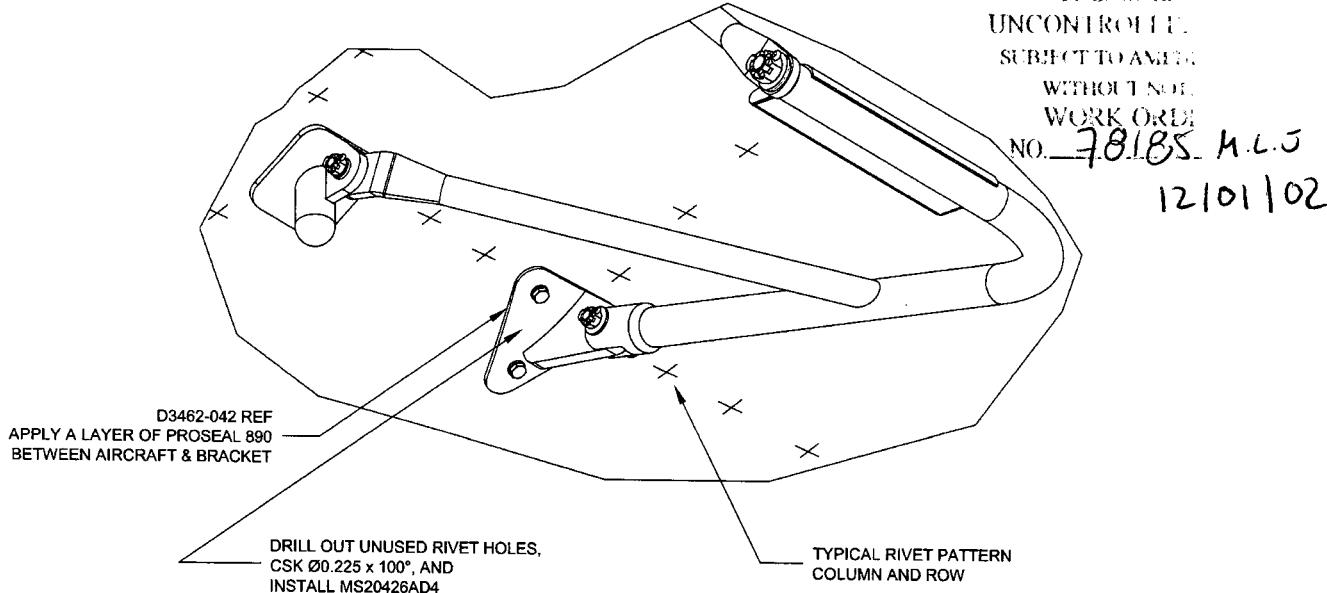
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

**FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown),
D412-630-031 LH (Opposite)**



**FIGURE 22 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown)
D3462-041, (-031 Installation Opposite)**

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Revision: M
Date: 08.12.12

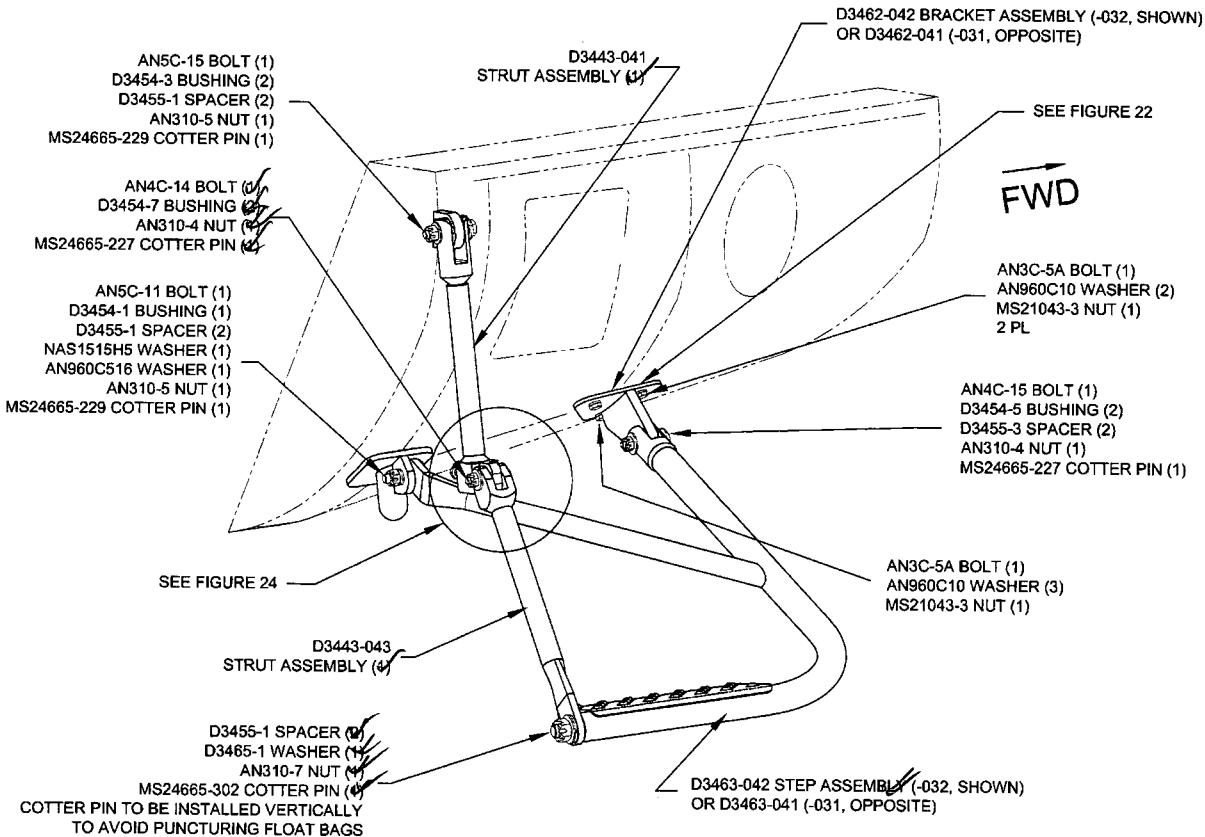
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

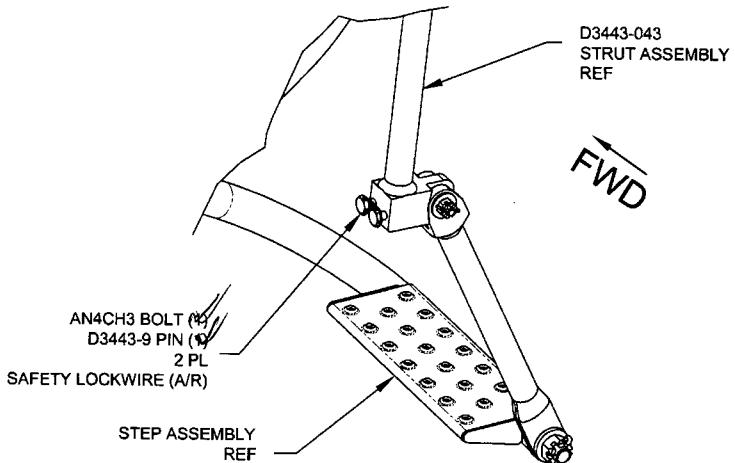
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D412-630

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Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
12	2	AN310-4	NUT
12	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH
D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP

